

Date: Tuesday, 20/01/2009 2:32:00 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FWD LH HARDPOINT	
Job Number : 44957		
Estimate Number : 13748		
P.O. Number :	Part Number : D3870041	
This Issue : 20/01/2009 S.O. No. :	Drawing Number : D3870 PRELIM	
Prsht Rev. : NC	Project Number : N/A	
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : PRELIM	
Previous Run :	Material :	
Written By : <u> </u>	Due Date : 27/01/2009	Qty: 4 Um: Each
Checked & Approved By : <u> </u>		
Comment : Est Rev:A 09-01-20 as per prelim issue DD verified by:ec		



Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D38701	Base
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Base

batch: 44958

2.0	D38703	Rib
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rib

batch: 844959

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- assemble D3870-1 to D3870-3 and weld as per dwg D3870

****It is acceptable to grind corners to facilitate fitting to the D3870-1****

A/R Aluminum welding rod batch: m109560

4.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

PD 09-01-27 (4)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING APPROVAL

09-01-27



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 20/01/2009 2:32:00 PM
Jser: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD LH HARDPOINT

Job Number: 44957

Part Number: D3870041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

JH 09-01-07

(X)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 09/01/07 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P/N and B/N using a permanent fine point marker, then Stock
Location: *PDP 44964*

SS 09/01/08 X4

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17

Job Completion



u 09-06-28

POSITIVE RECALL
EFFECTIVE *09-01-20* AUTH *u*
RELEASED *u* DATE *09-02-17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

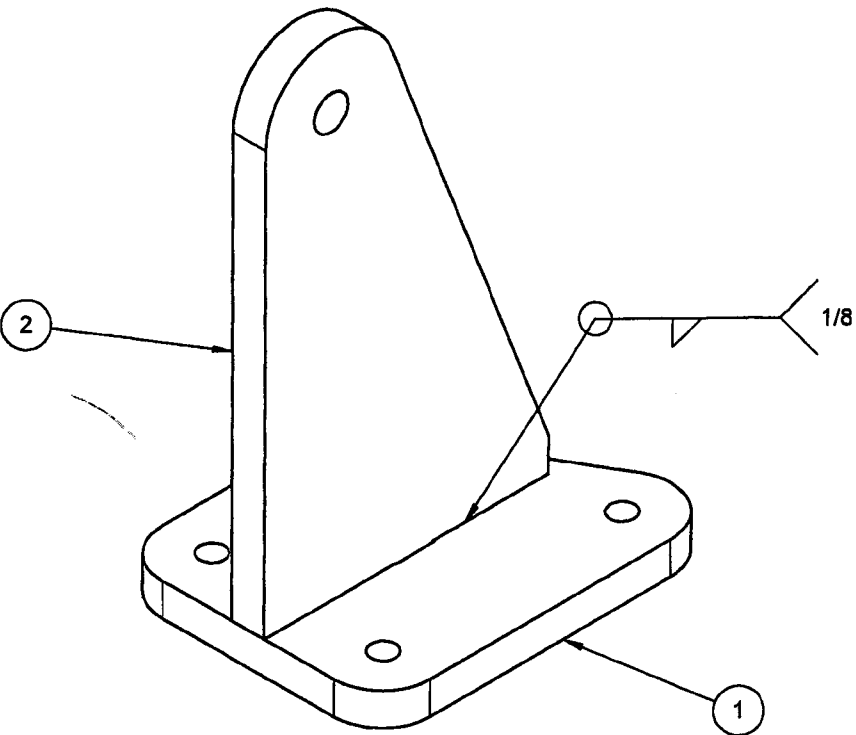
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

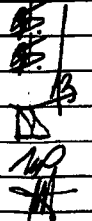
ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3870-1	BASE	1
2	D3870-3	RIB	1



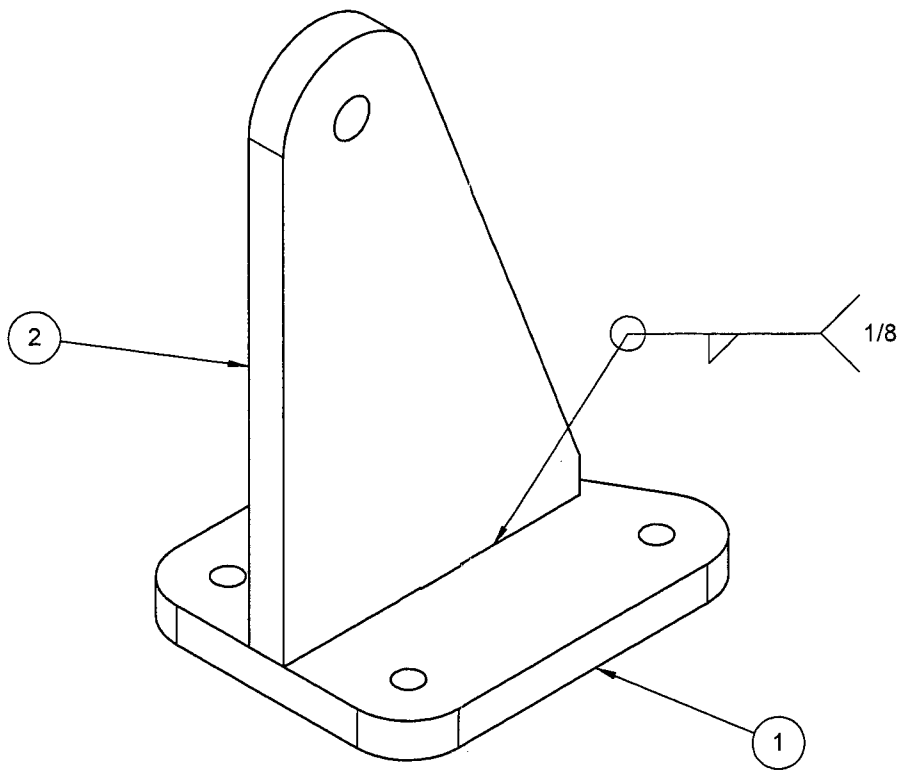
D3870-041 FWD LH HARDPOINT

44957
PRELIMINARY ISSUE
09/01/11

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3870-041" & B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.09 lbs
 - 8) WELD PER DART QSI 004

A	NEW ISSUE	BY	08.12.11
REV.	DESCRIPTION		DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3870	SHEET 1 OF 5
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DE APPR.	MOUNT	NTS	
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3870-1	BASE	1
2	D3870-3	RIB	1



D3870-041 FWD LH HARDPOINT

NOTES:

- 1) MATERIAL: N/A
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